

Page 1 November 6, 2009 8:14:58 AM D2570 Accept Item ID: Setup Start **Revision ID:** В Stop **Item Name:** Bushing **Start Qty: 300.00 Start Date:** 13/11/2009 **Cust Item ID:** Req'd Qty: 300.00 **Required Date: 13/11/2009 Customer:** Reference: Run Start Date 09/1/ Tooling: **Process Plan: Approvals:** Date: Stop Date: Date: QC: **SPC (Y/N):** Sequence ID/ Set Up/ Reject Operation Draw Draw Plan Accept Reject Insp. **Work Center ID** Description Number Rev. Code Qty Number Stamp **Run Hours** Qty **Draw Nbr Revision Nbr** D2570 Rev B 100 0.00 100/11/07 Hardinge CNC LATHE SMALL Hardinge Memo Hardinge CNC Lathe Small Machine as per folio FA258□Deburr 110 QC2- Inspect parts off machine FAI/FAIB 0.00 Memo Quality Control 120 QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

314 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mg	Approval QC Inspector		
05111.67	[00	USED 324 INSTEAD OF 307 Balabisos LB112567 RAN OUT OF 303 BALL 304: B109608 : B109671	12	04/1/12		04.11.09 08.071	Splulse		

Part No: PAR #:		PAR #:	Fault Ca	tegory: NC	R: Yes N	o DQA:	_ Date: _	
		esolution:	Disposition: (\: N/C Clos	sed:	Date: _	
NCR:	- , ,	W	ORK OR	DER NON-CONFORMANCI	E (NCR)		-	_
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
		OF MATIL	08.11.05 QS1011	ACCEPTABLE			91.11.05 Pr 951042	MA
								-

NOTE: Date & initial all entries

Work Order ID 53449

November 6, 2009 8:14:58 AM

Page 2

Item ID:

D2570

Accept

Setup Start

Stop

Revision ID: В

Item Name: Bushing

13/11/2009

Required Date: 13/11/2009 Req'd Qty: 300.00

Start Qty: 300.00



Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

QC:

Date:

Tooling: Date:

SPC (Y/N):

Set Up/

Run Hours

Draw Number

Draw Rev.

Date:

Date:

Plan Code

Accept Qty

9/11/16

Reject Qty

Reject Number

Insp. Stamp

130

Sequence ID/

Work Center ID

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:____

Memo

0.00

0.00



QC

140

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Run

Start

Stop

Picklist Print

November 6, 2009 8:15:04 AM

Work Order ID: 53449

D2570RevB

Parent Item Name:

Bushing



Start Date: 13/11/2009

Required Date: 13/11/2009

Start Qty: 300.00

Required Qty: 300.00

Comments:

Item Name

Parent Item:

Replacement Mfg/ Component Item ID/ Item ID

Purch

Bin **Primary** Item Location

Last Location

113134

Route Seq ID Unit of Measure Hand

Qty on

Remaining Qty To Pick Issued

Qty

Date Issued

Status

Page 1

M303R0.750

Purchased

No

100

f

85.4767

24.3474

303 Round Bar 0.750

111 parts

<u>Warehouse</u>	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	85.47667895	
107077	0	•
107857	18.121579	
108220	10.69	
108877	14.41	
110166	10.16	
110680	9.29	
111323	7.9301	
112567	14.875	

Movilor

304 RLOO B 107508 -3 3 Rt

43 parts

13107541

S ONIVOR

DART AEROSPACE LTD	Work Order:	53449
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First A	ticle	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	.801	//			
0.060	+/-0.005	.060	7			
R0.010	+0.010/-0.000	R -015				
Ø0.425	+0.000/-0.002	4235				
Ø0.257	+0.006/-0.001	0.259			<u> </u>	
Ø0.750	+/-0.010	:744	/	<u> </u>		
0.030 x 20°	+/-0.010	30828				
					·	
						,
·						
			<u> </u>			

Measured by:	Audited by:		Prototype Approval:	N/A
Date:	Date: 09/	1//3	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
С	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM 1/A	
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD 9	



DESIGN DRAWN BY		1 -	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHEC	KED , d	APPROVED	DRAWING NO. REV.	. В		
	世	H	D2570 SHEET 1 OF	F 1		
DATE			TITLE SC/	V.E		
07.0)4.17		BUSHING	1:1		
Α		96.09.16	NEW ISSUE			
В		07.04.17	UPDATE NOTES			

UNCONTROLL ALC: Y SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 534419 Ø0.750 · BN 09-11-6 - ø0.257+0.005 Ø0.425^{+0.000}_{-0.002}

STODER

EMOING ALL OF

- 0.800±0.010 0.060±0.005 --0.030 X 20° R0.010 (REF)

D2570 BUSHING

D2570 BUSHING

1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)

- 2) FINISH:
- NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX 5)

مله

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